

Aero Design Ltd.

Work Order Control Sheet

Work Order#: 2014-84 Date Opened: 24 Oct 2014 Title: Assembly

Aircraft OEM: Bell Aircraft Model: 429 (Post-081) Product Type: Cargo Basket Product Model: Standard Quantity: 1

Work Order Contents

Work Order/Build Sheets (Procedures Provided)
Additional Work Sheets (Standard Practice)
Drawings (See List Below)
Parts Distribution Sheet
Sub Component Tags
Completed Certification (Original)
Time Sheet (R&D)
Notes

Initial or N/A

JR
N/A
JR
JR
N/A
JR
N/A
N/A

Build Sheet Contents

Tasks Initialled
Dual Inspections Initialled

Initial or N/A

JR
JR

Drawing List

Drawing #	Rev #	Description	Initial or N/A
95912	1	Lid	JR
95932	0	Fwd Beam	JR
95933	0	Aft Beam	JR
95950	0	Basket Assembly x2	JR
95951	0	Basket Fabrication	JR
95964	0	Fwd Hoop	JR
95965	0	Fwd Sheet	JR

Traveller

Initial or N/A

Component Completion

Quantity Complete on This Work Order
Quantity Incomplete on This Work Order
Further Processing Required Before Release
Release to Stock as Components

As Instructed

1
N/A
N/A
N/A

Certification

Form One Completed
Serviceable (Green) Tag Completed
In Process (Yellow) Tag Completed
Unserviceable (Red) Tag Completed
Parts Placed in Stores for Distribution

Initial or N/A

N/A
N/A
N/A
N/A
N/A

Additional Documentation

Documentation of a minor change
Non-Conformance Report Required
Service Difficulty Report Required

Initial or N/A

N/A
N/A
N/A

Billing

Local (Aero Design)
Research and Development
Third Party

Initial or N/A

JR
N/A
N/A

Work performed by:

Print: Jason Rekve

Sign: Jason Rekve

SCA: AD01

Date: 24-Oct-14

ICC / Dual Inspection performed by:

Print: Jeff Clarke

Sign: Jeff Clarke

SCA: AD02

Date: 31-Oct-14

Work Order closed by:

Print: Jason Rekve

Sign: Jason Rekve

SCA: AD01

Date: 31-Oct-14


Approved Manufacturing Facility 73-04

Form 20.D.03

Rev. Original 23 Sep 2014

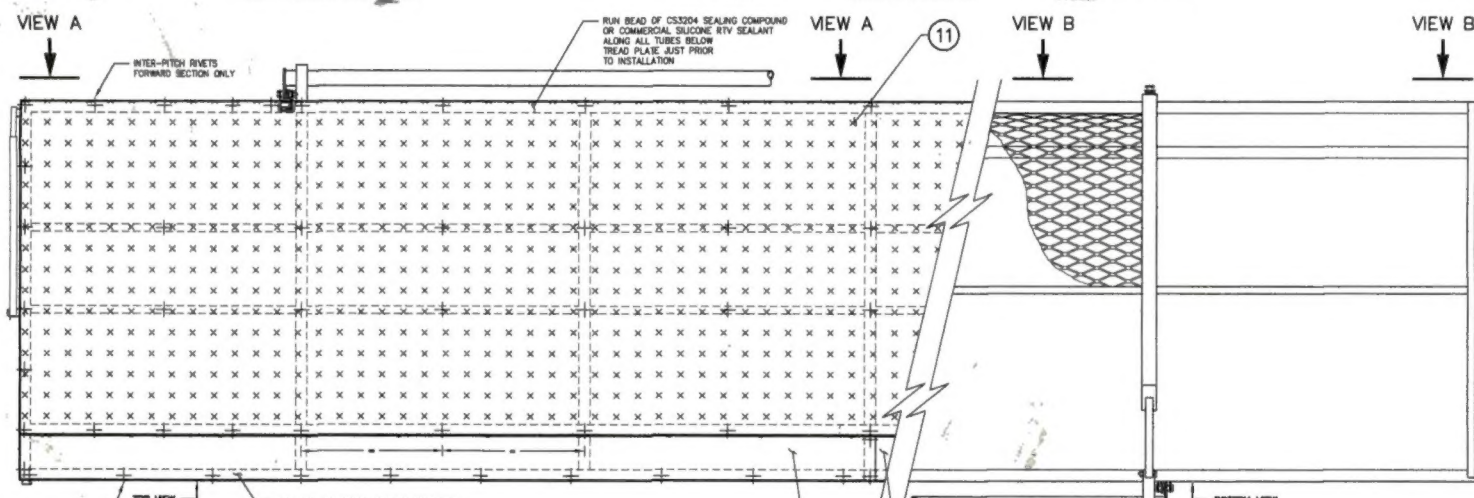
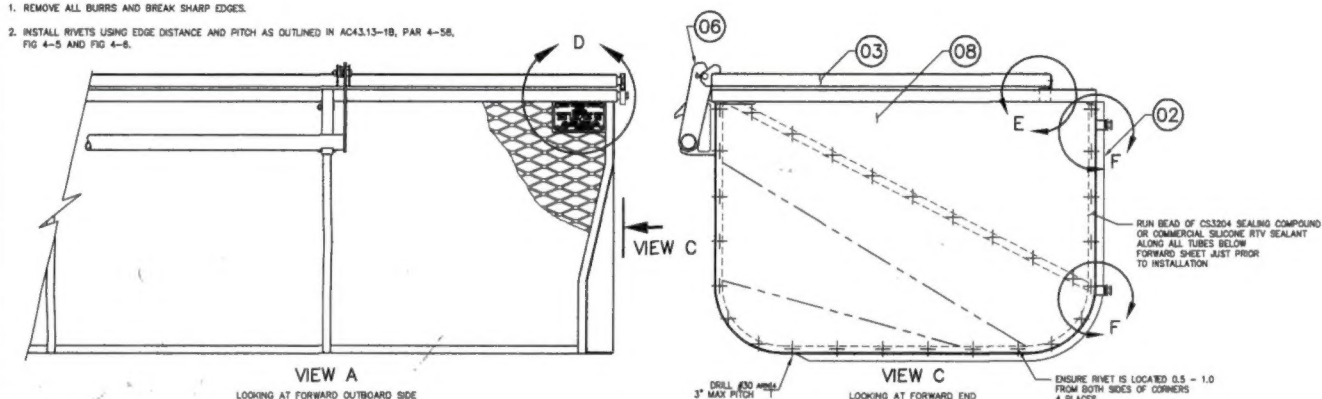
p.o. # 14059

1	96920-02	02	LH STEP BRACKET	6061-T6 ALUMINUM	QQ-A-200/8	4 X 1 BAR
1	96920-01	01	RH STEP BRACKET	6061-T6 ALUMINUM	QQ-A-200/8	4 X 1 BAR
	PART NO.	ITEM	DESCRIPTION	MATERIAL	MATERIAL SPEC	STOCK SIZE
QTY						
LIST OF MATERIALS						

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	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES. TOLERANCES ON: DECIMALS ANGLES X.XXX ±0.010 ±1/2" X.XX ±0.03 X.X ±0.1			BELL 429 CABIN STEPS FIXED STEP BRACKET FABRICATION		
	SCALE 1 : 1 SHEET 1 OF 1			DWS. SIZE A3	DWS. NO. 96920	REV. 1

NOTES

1. REMOVE ALL BURRS AND BREAK SHARP EDGES.
2. INSTALL RIVETS USING EDGE DISTANCE AND PITCH AS OUTLINED IN AC43.13-1B, PAR 4-5B, FIG 4-5 AND FIG 4-6.



01 BASKET BODY ASSEMBLY
RIGHT HAND SHOWN, LEFT HAND OPPOSITE

09/13 (ALTERNATE)

04

05

06

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149

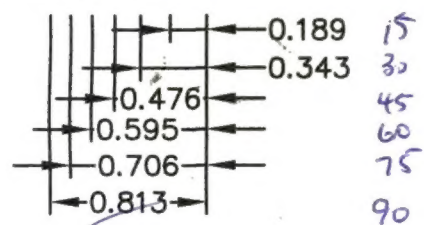
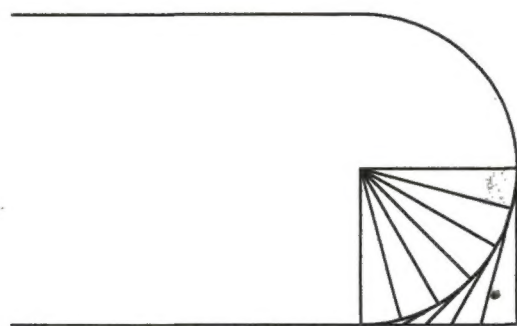
150

151

152

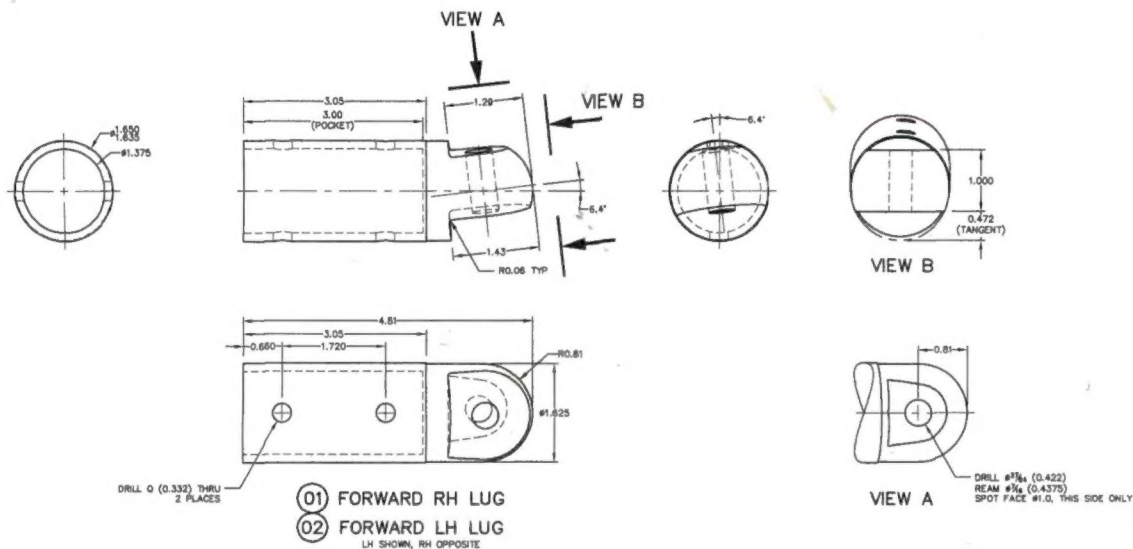
153

154

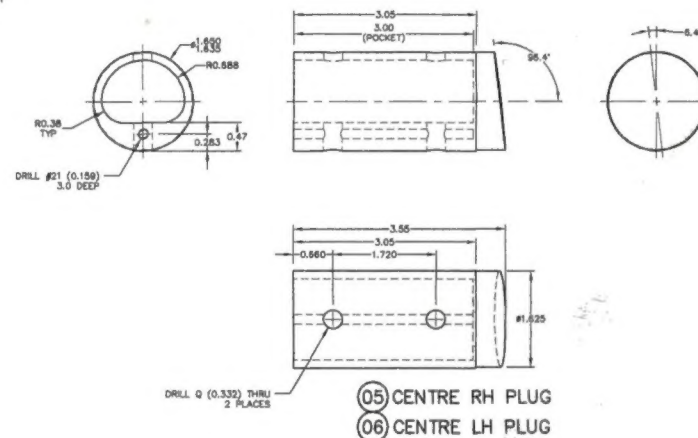
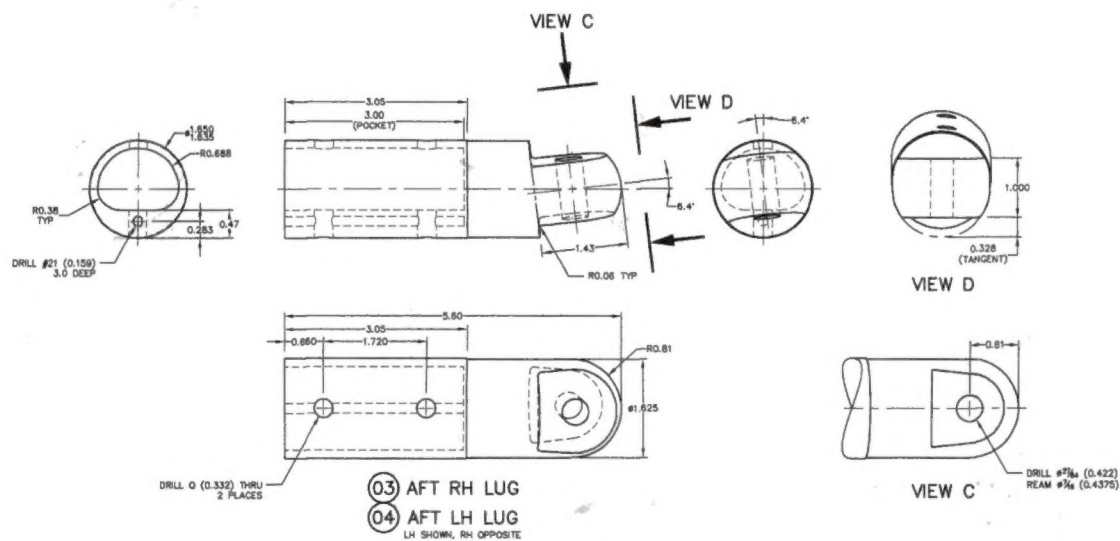


4.85 long

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REV	DESCRIPTION OF CHANGE	INITIALS	DATE
0	INITIAL ISSUE		



- NOTES
1. REMOVE ALL BURRS AND BREAK SHARP EDGES.
 2. THOROUGHLY DEGREASE, ALODINE AND EPOXY PRIME ALL ALUMINUM PARTS PRIOR TO ASSEMBLY.
ALTERNATE: ANODIZE IN ACCORDANCE WITH MIL-A-8825F, TYPE III.



PART NO.	ITEM	DESCRIPTION	MATERIAL	MATERIAL SPEC	STOCK SIZE
1	95940-08 08	CENTRE LH PLUG	6061-T6 ALUMINUM	QQ-A-200/8	#2.0 ROUND BAR
1	95940-05 05	CENTRE RH PLUG	6061-T6 ALUMINUM	QQ-A-200/8	#2.0 ROUND BAR
1	95940-04 04	AFT LH LUG	6061-T6 ALUMINUM	QQ-A-200/8	#2.0 ROUND BAR
1	95940-03 03	AFT RH LUG	6061-T6 ALUMINUM	QQ-A-200/8	#2.0 ROUND BAR
1	95940-02 02	FORWARD LH LUG	6061-T6 ALUMINUM	QQ-A-200/8	#2.0 ROUND BAR
1	95940-01 01	FORWARD RH LUG	6061-T6 ALUMINUM	QQ-A-200/8	#2.0 ROUND BAR
LIST OF MATERIALS					
APPROVALS		DATE	 AERO DESIGN LTD. 9008A MALASPINA ROAD POWELL RIVER, BC, CANADA, V8A 0G5 TEL: 604-681-5276 www.aerodesign.ca		
DRAWN: JEFF CLARKE		21 JAN 2014			
CHECKED: JASON REKVE		21 JAN 2014			
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES. TOLERANCES ON:			BELL 429 - S/N 57081 & SUB. QUICK RELEASE CARGO BASKET LUG FABRICATION		
DECIMALS			SCALE 1 : 1		
X.XXX ±0.010			SHEET 1 OF 1		
X.XX ±0.03			A1		
X.X ±0.1			95940		
			0		

5.65 long

B429 Post S/N 81 Fittings

Setup Notes

Rotate vise 6.4° CW = LH CCW = RH

Rotate head towards operator 6.35°

* ensure head is aligned to Y axis *

Set \emptyset
X:



- 1 touch one side, set \emptyset X
 - 2 touch other side (2.125 nom)
 - 3 Split reading from 2 (1.063 nom)
- Set \emptyset X

Set \emptyset Y



touch close side, set \emptyset Y

Set \emptyset Z



with cutter @ XO Y 1.063 touch top.

MID ✓

~~MID~~ / AFT

FITTINGS - HOLE CLOS

~~MID HOLE FIT~~



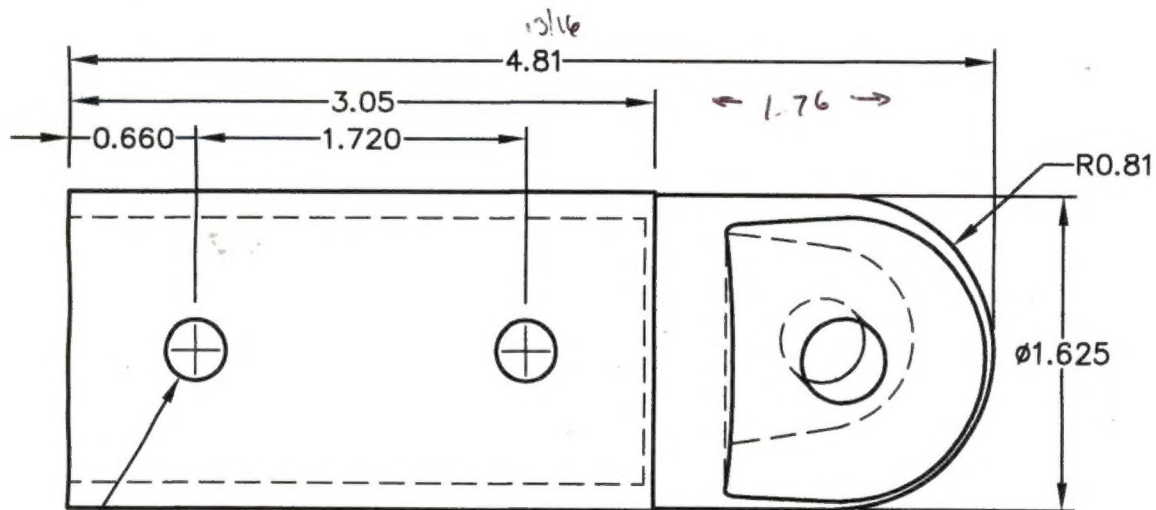
set face flat on bar $\frac{3}{4} \times \frac{1}{2}$



~~Verify~~ $\phi 7/16$ hole - set @ 0.810

$\phi 1.0$ Bore - set @ 0.830 to ensure clearance

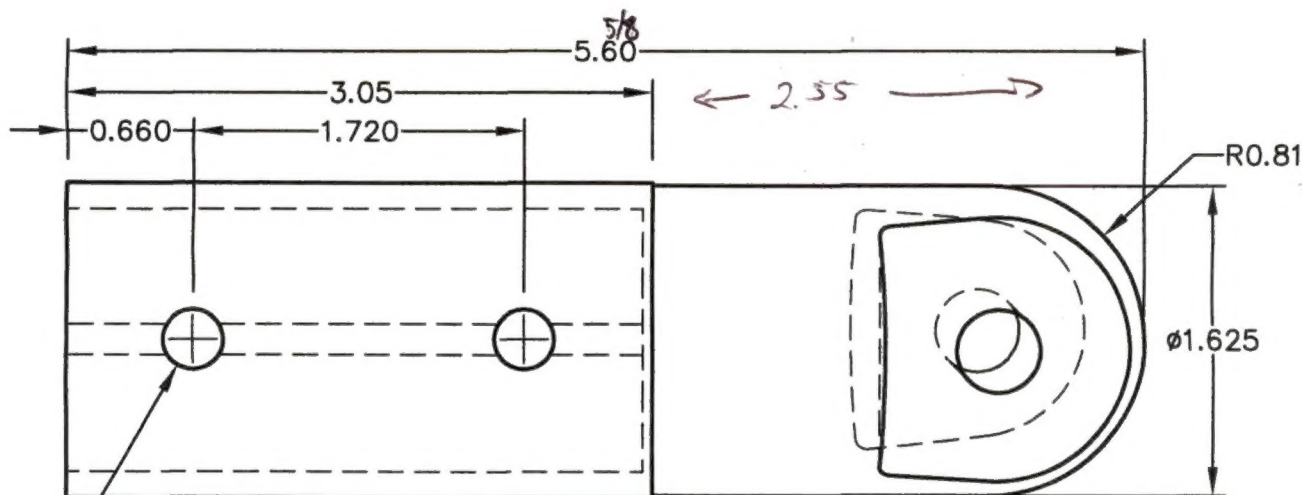
4.81
3.05
1.76



DRILL P (0.323) THRU
2 PLACES

- (01) FORWARD RH LUG
(02) FORWARD LH LUG
LH SHOWN, RH OPPOSITE

5
5.6
3.05
2.55



DRILL P (0.323) THRU
2 PLACES

03 AFT RH LUG

04 AFT LH LUG

LH SHOWN, RH OPPOSITE

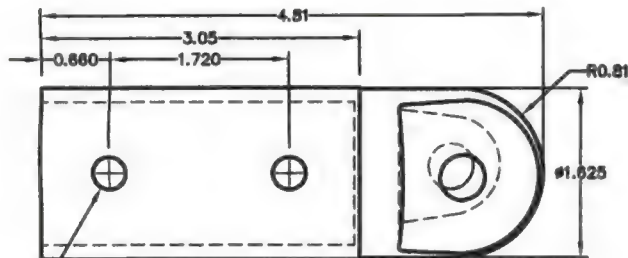
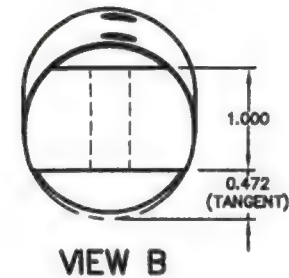
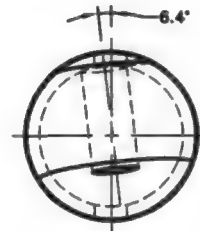
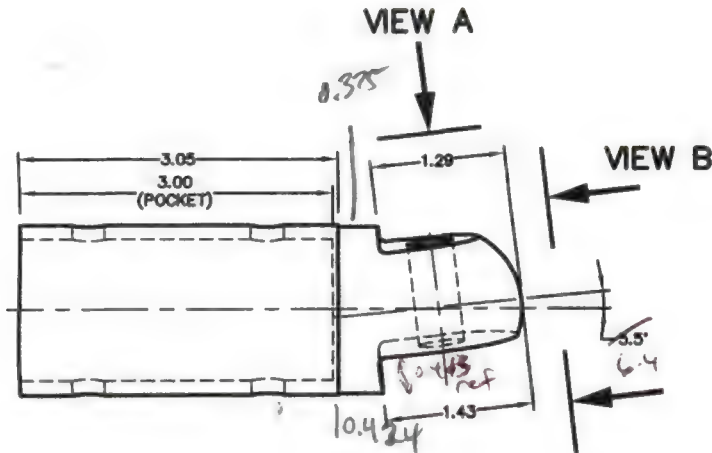
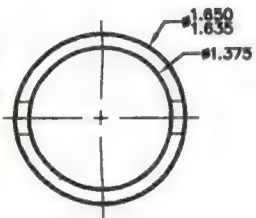
0.75
1.43
2.18

1.034
1.214

Back side Nom 1972 +

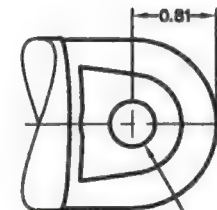
3.05
0.424
3.474

3.05
0.375
3.425



DRILL P (0.323) THRU
2 PLACES

- (01) FORWARD RH LUG
 - (02) FORWARD LH LUG
- LH SHOWN, RH OPPOSITE

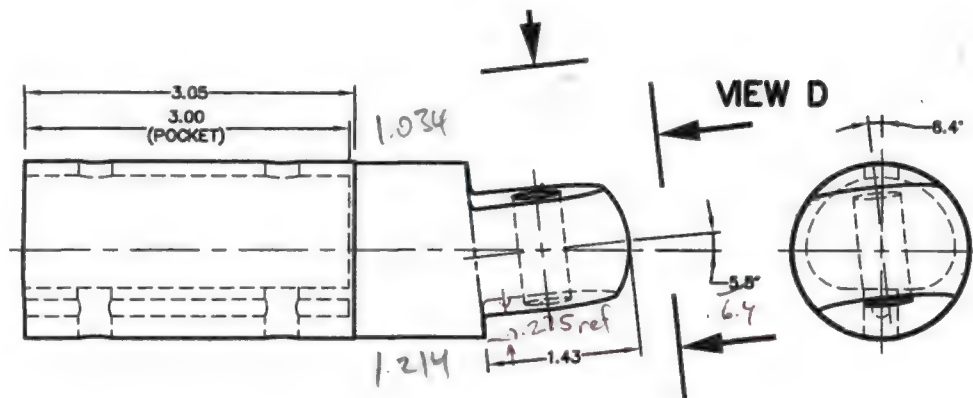
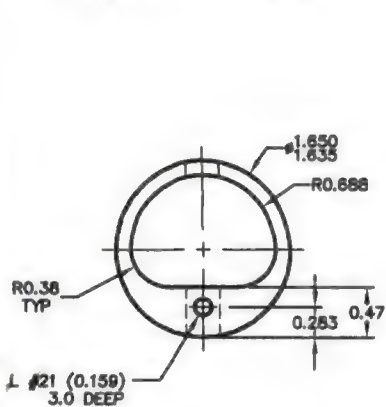


VIEW A

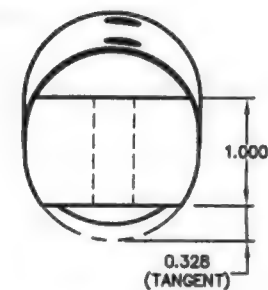
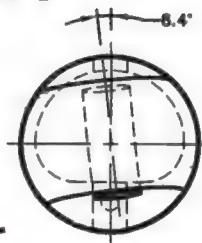
DRILL $\frac{3}{16}$ (0.422)
REAM $\frac{3}{16}$ (0.4375)
SPOT FACE #1.0, THIS SIDE ONLY

$$\begin{array}{r} 2.05 \\ 1.214 \\ \hline 3.264 \end{array}$$

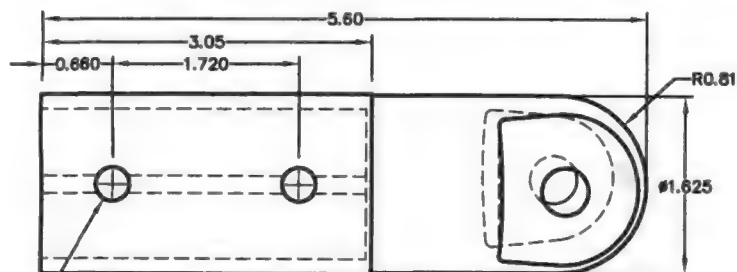
$$\begin{array}{r} 3.05 \\ 1.034 \\ \hline 4.084 \end{array}$$
 Back side now 1.828 +



VIEW D

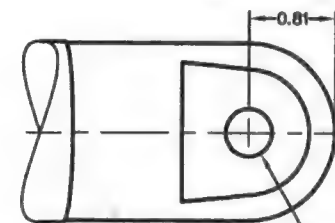


VIEW D



DRILL P (0.323) THRU 2 PLACES

03 AFT RH LUG
 04 AFT LH LUG
 LH SHOWN, RH OPPOSITE

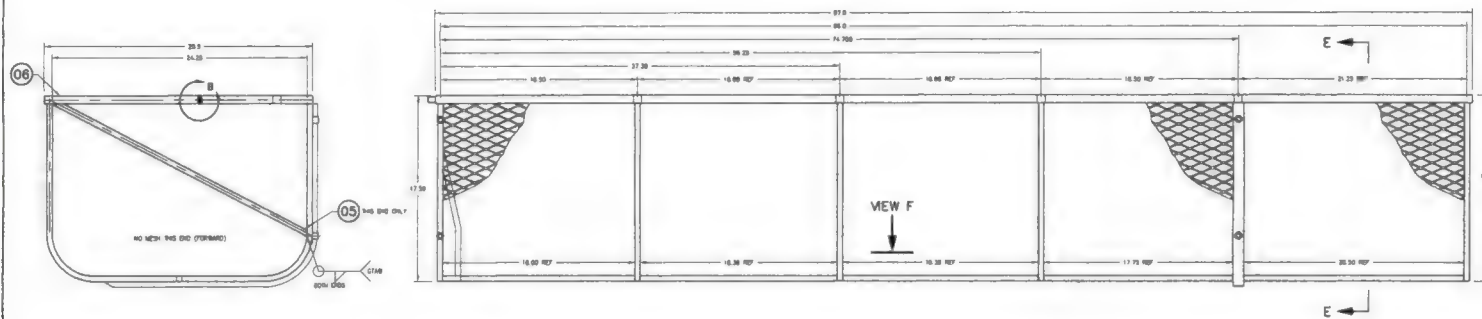


VIEW C

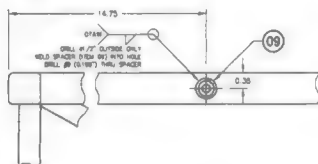
DRILL 27/64 (0.422)
 REAM 3/8 (0.4375)



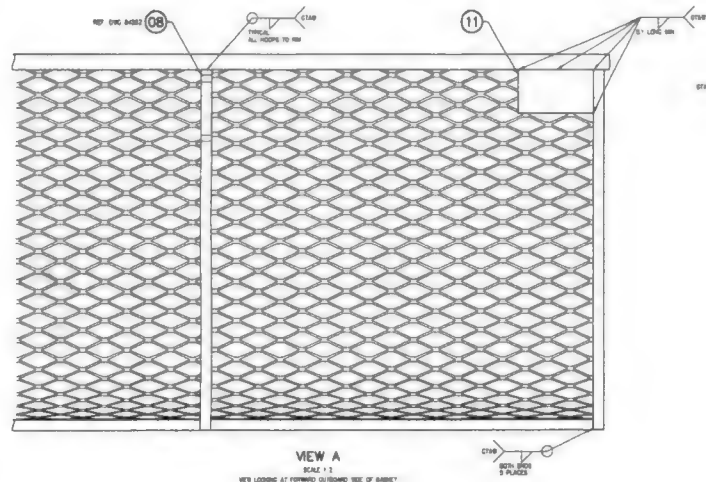
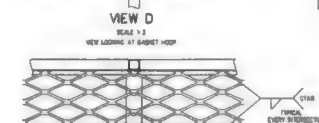
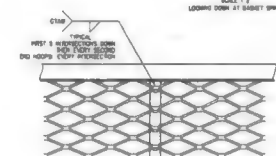
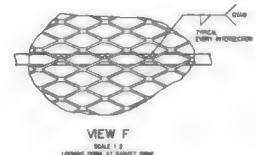
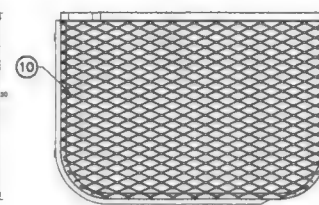
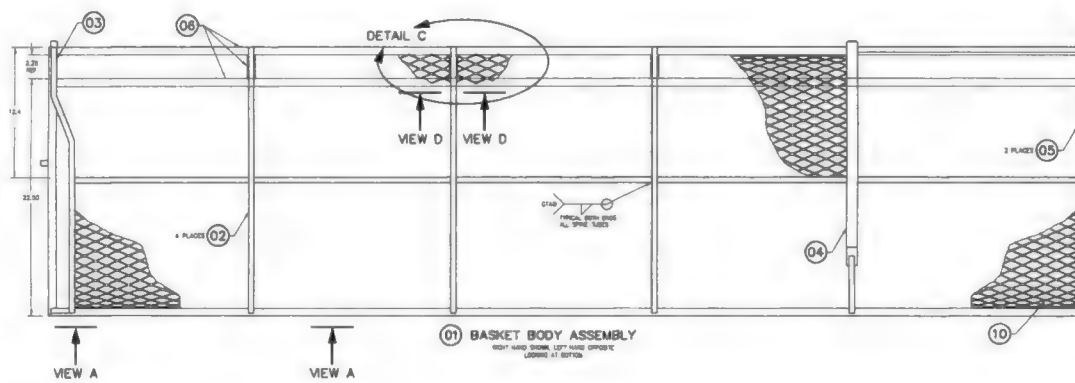
From PO or WO #	Quantity	Description	Part Number	For WO #
511 511 05	1	LUG	95925-03	2014-84
511 511 05	1	LUG	95925-02	2014-84
2014-58	54	HOOP	9520-01	2014-84
14060	1	JUGGLE HOOP	95964-01-01	2014-84
2012-24/14060		MOUNT HOOP	9546426 01	2014-84
LTD 3/4" Rim	140061			
LTD 3/4" ENDS	14009			
LTD 3/4" crossmembers	14009			
LTD 1/2" walkway struts	14060			
Basket Rim	1			
Basket 2 1/2" 3/4"	1211			
Basket 5 1/2" pipe	12123			
Basket ends	13047			
Basket spare	14060			



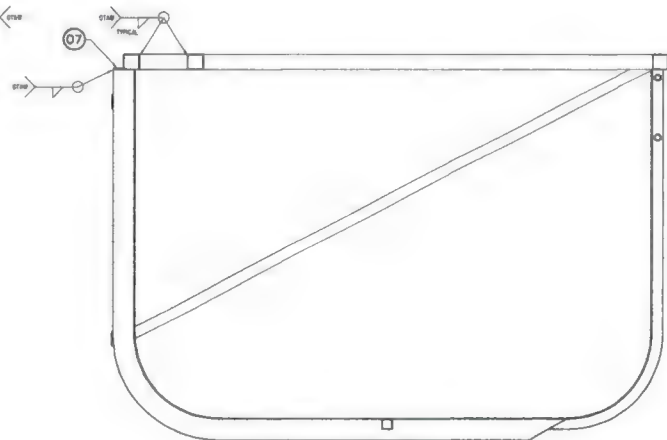
1. REMOVE ALL BURRS AND BREAK SHARP EDGES
2. WELDING OF #130 STEEL TO BE COMPLETED BY O'GAIN METHOD TO AWS D88.8C
3. #140 AND #118 STEEL WELDING ROD SHALL CONFORM TO ER70S-2 OR EQUIVALENT STAINLESS STEEL, AND #130 WELDING ROD SHALL CONFORM TO ER308L OR EQUIVALENT
4. WHEN ASSEMBLY IS COMPLETE, FILL ALL EXPOSED VENT HOLES WITH POSITIVE WELD
5. THOROUGHLY CLEAN AND POWDER COAT BASKET SUB-ASSEMBLY PRIOR TO ASSEMBLY



DETAIL B
SCALE 1:1
VIEW LOOKING AT FRONT END OF BATTERY



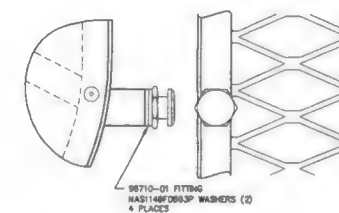
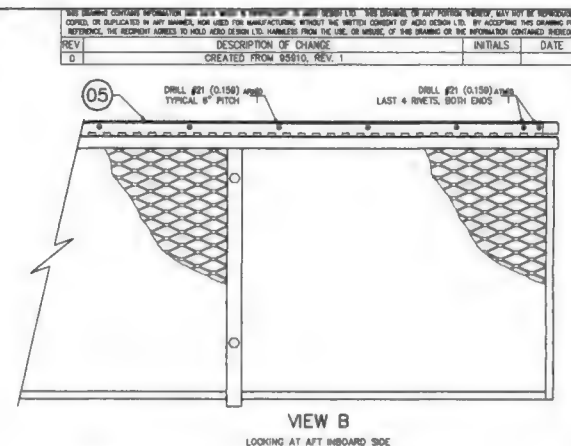
VIEW A
SCALE = 2
WITH LOOKING AT FORMER OUTLINED SIDE OF BATTERY



SECTION E-E
SCALE 1/2
VIEW LOOKING FORWARD THROUGH SHEDS


[illegible]

1. REMOVE ALL BURRS AND BREAK SHARP EDGES.
2. INSTALL RIVETS USING EDGE DISTANCE AND PITCH AS OUTLINED IN AC43.13-1B, PAR 4-5B, FIG 4-5 AND FIG 4-6.



SCALE 1 1
LOOKING AT FORWARD LOWER ATTACHMENT, UPPER ATTACHMENT SIMILAR
REAR ATTACHMENTS SIMILAR

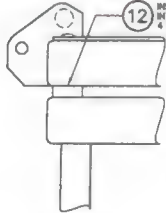
A/R	A/R		SILICONE SEALANT (CLEAR)	COMMERCIAL
A/R	A/R	CS3204	SILICONE SEALING	AUS-S-8802C T2 B1
B	B	NAST149F06B3P	WASHER	
B	B	9870-C-01	FITTING	ALT ANISA 4008B-14
A/R	A/R	CR3211-S-02	CHEMRY RINET	ALT HR3211-S-02
B	B	CR3521-S-02	CHEMRY RINET	ALT HR3521-S-02
A/R	A/R	CR3211-S-02	CHEMRY RINET	ALT HR3211-S-02
A/R	A/R	95816-03	FLYER SHEET	ALTERNATE TO 06/10
A/R	A/R	4020S-12	12 BUMPER	ANGLE INDUSTRY
1	1	95917-02	1H LH CHOKER PLATE	
1	1	95917-01	1H RH LH CHOKER PLATE	
1	1	95918-02	1O FILLER SHEET	
1	1	95914-01	09 FORWARD SHEET	
1	1	95865-02	08 LH FORWARD SHEET	
1	1	95865-01	08 RH FORWARD SHEET	
1	1	95927-04	07 LH PLACARD	
1	1	95927-03	07 RH PLACARD	
1	1	84255-01	06 HANDLE BAR INSTALLATION	
1	1	MZ002P0A-01	05 PIANO HINGE	SG LONG
1	1	84245-01	04 BRACE INSTALLATION	
1	1	95912-01-02	03 LH UD ASSEMBLY	
1	1	95912-01-03	03 RH UD ASSEMBLY	
1	1	95801-01-02	02 LH BASKET BODY ASSEMBLY	
1	1	95951-01-01	02 RH BASKET BODY ASSEMBLY	
1	1	95850-01-01	01 RH CARGO BASKET ASSEMBLY	
1	1	95850-01-01	01 RH CARBO BASKET ASSEMBLY	
-02-01	-02-01	PART NO.	ITEM DESCRIPTION	MATERIAL
QTY	QTY		LIST OF MATERIALS	

 9885A MALASPINA ROAD
POWELL RIVER, BC, CANADA, V8A 0G3
TEL: 804.482.2976 www.aerodesign.ca

SCALE 1 : 4	DWG. SIZE	DWG. NO.	REV
SHEET 1 OF 1	A1	95950	0

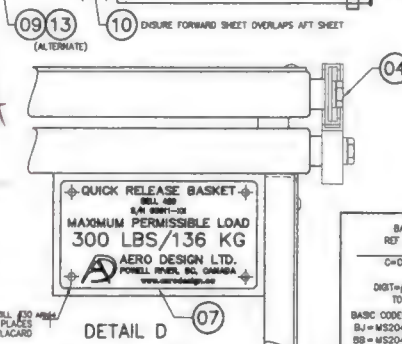
DRILL #30 APERTURE
6" PITCH

BUMPER INSTALLATION






05 0.25 MIN
TYP

DETAIL E
SCALE 1 - 1
LOOKING AT HINGE



DETAIL D
SCALE 1 : 1
HING AT PLACARD BRACKET

BASIC CODE REF NAS 323	DASH NO. FOR DIAMETER H=MFD HEAD NEAR SIDE N=MFD HEAD FAR SIDE
C=COUNTERSINK D=DIMPLE DIGIT# OF SHEETS TO BE DIMPLED	DASH NO. FOR LENGTH
BASIC CODES: BJJ = M52047QAD BB = M520426AD ARN = CR3213 ATM = CR3523	 INSTALL NEW RIVET  REMOVE/REPLACE RIVET  EXISTING RIVET

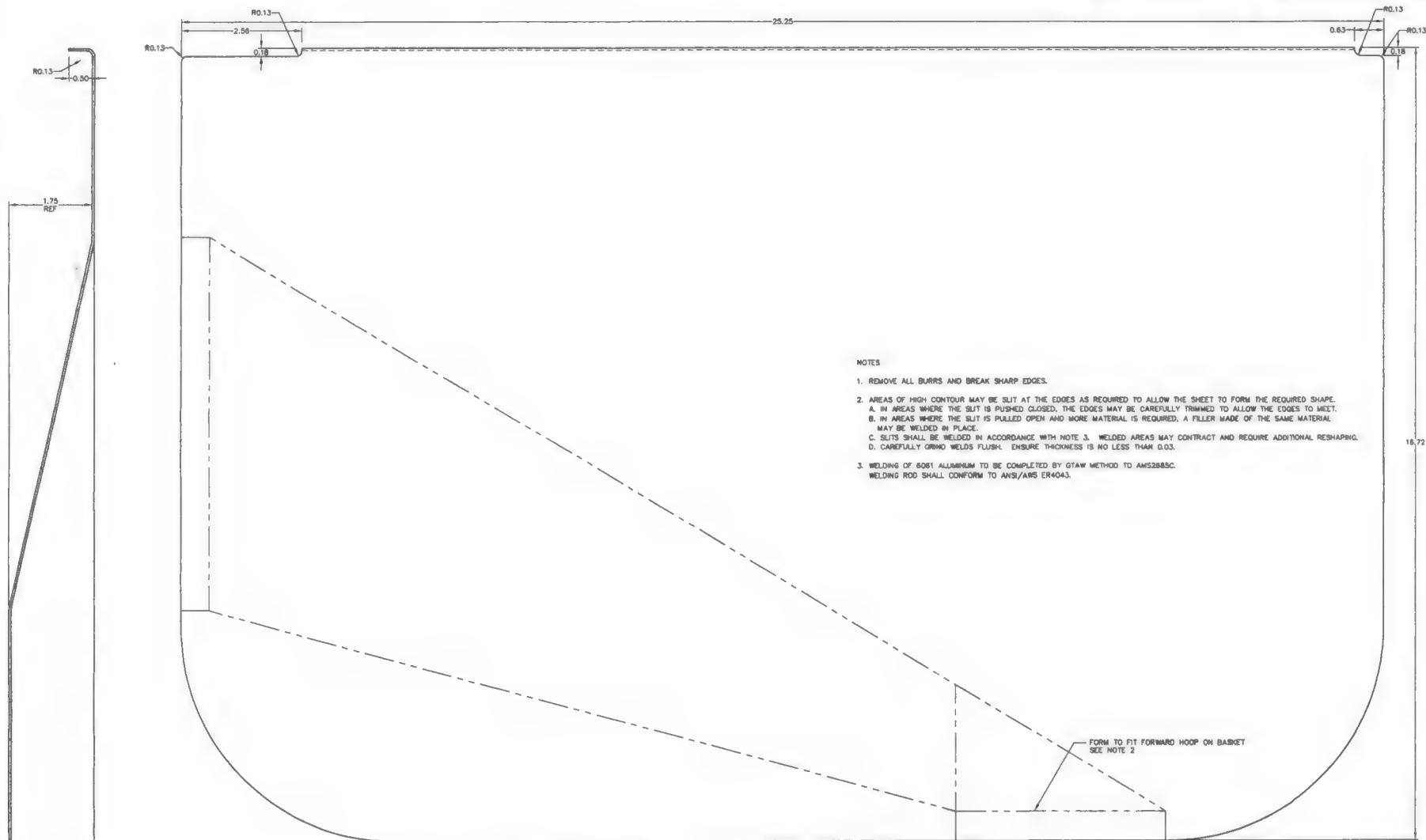
APPROVALS		DATE
DRAWN: JEFF CLARKE	20 FEB 2014	
CHECKED: JASON REKVE		

UNLESS OTHERWISE SPECIFIED
DIMENSIONS ARE IN INCHES.
TOLERANCES ON:

DECIMALS	ANGLES
X.XXX ±0.010	±1/2°
X.XX ±0.03	
X.X ±0.1	

	AERO DESIGN LTD.		
	9066A MALAPASITA ROAD POWELL RIVER, SC, CANADA, V8A 0G3		
	TEL. 804-458-2570 www.aerodesign.ca		
BELL 429 - S/N 57081 & SUB. QUICK RELEASE CARGO BASKET CARGO BASKET ASSEMBLY			
SCALE 1 : 4	QWS SIZE	QWS NO.	REV
SHEET 1 OF 1	A1	95950	0

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REV.	DESCRIPTION OF CHANGE	INITIALS	DATE
0	INITIAL ISSUE		



NOTES

1. REMOVE ALL BURRS AND BREAK SHARP EDGES.
2. AREAS OF HIGH CONTOUR MAY BE SLIT AT THE EDGES AS REQUIRED TO ALLOW THE SHEET TO FORM THE REQUIRED SHAPE.
 - A. IN AREAS WHERE THE SLIT IS PUSHED CLOSED, THE EDGES MAY BE CAREFULLY TRIMMED TO ALLOW THE EDGES TO MEET.
 - B. IN AREAS WHERE THE SLIT IS PULLED OPEN AND MORE MATERIAL IS REQUIRED, A FILLER MADE OF THE SAME MATERIAL MAY BE WELDED IN PLACE.
 - C. SLITS SHALL BE WELDED IN ACCORDANCE WITH NOTE 3. WELDED AREAS MAY CONTRACT AND REQUIRE ADDITIONAL RESHAPING.
 - D. CAREFULLY GRIND WELDS FLUSH. ENSURE THICKNESS IS NO LESS THAN 0.03.
3. WELDING OF 6061 ALUMINUM TO BE COMPLETED BY GTAW METHOD TO AMS2885C. WELDING ROD SHALL CONFORM TO AWS/AMS ER4043.

01 FORWARD SHEET
RH SHOWN, LH OPPOSITE

QTY	QTY	PART NO.	ITEM	DESCRIPTION	MATERIAL	MATERIAL SPEC	STOCK SIZE
		85063-01	01	FORWARD SHEET (LEFT HAND)	6061 ALUMINUM	QQ-A-250/11	0.050 SHEET
		85063-01	01	FORWARD SHEET (RIGHT HAND)	6061 ALUMINUM	QQ-A-250/11	0.050 SHEET

APPROVALS		DATE	
DRAWN: JEFF CLARKE		10 APR 2014	
CHECKED: JASON REKVE			
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES. TOLERANCES ON:			
DECIMALS		ANGLES	
X.XXX ±0.010		±1/2°	
X.XX ±0.03			
X.X ±0.1			
SCALE 1:1		DWG. SIZE	
SHEET 1 OF 1		A1	

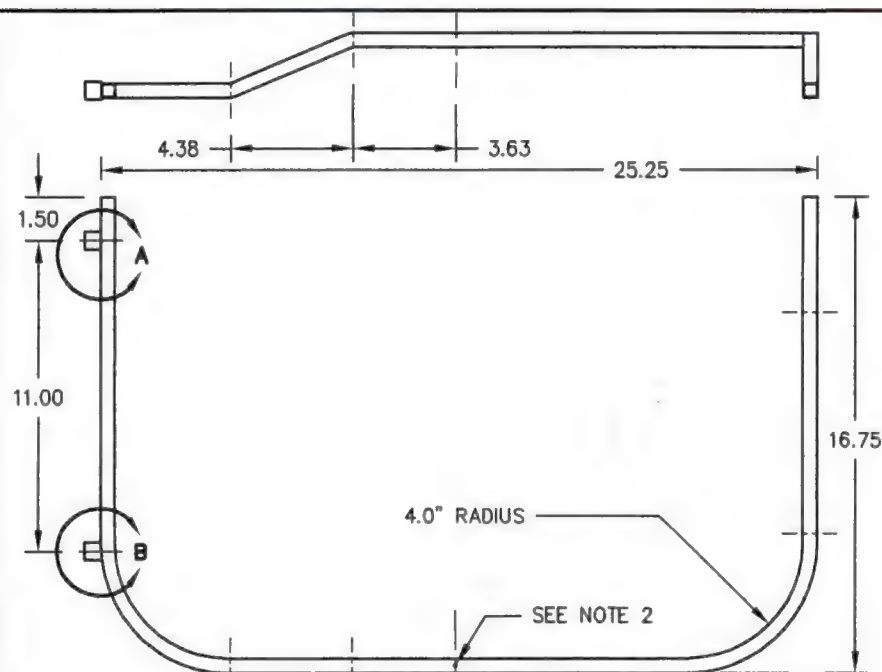
AERO DESIGN LTD.			
9690A MALAPRISA ROAD			
POWELL RIVER, BC, CANADA, V8A 0G3			
TEL: 604-484-8975 info@aerodesign.ca			
BELL 429 - S/N 57081 & SUB.			
QUICK RELEASE CARGO BASKET			
FORWARD SHEET			
SCALE 1:1		DWG. SIZE	
SHEET 1 OF 1		A1	
		95965	
		0	



AERO DESIGN LTD.

9608A MALASPINA ROAD
POWELL RIVER, BC, CANADA V8A 0G3
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BELL 429 - S/N 57081 & SUB.
QUICK RELEASE CARGO BASKET
FORWARD SHEET

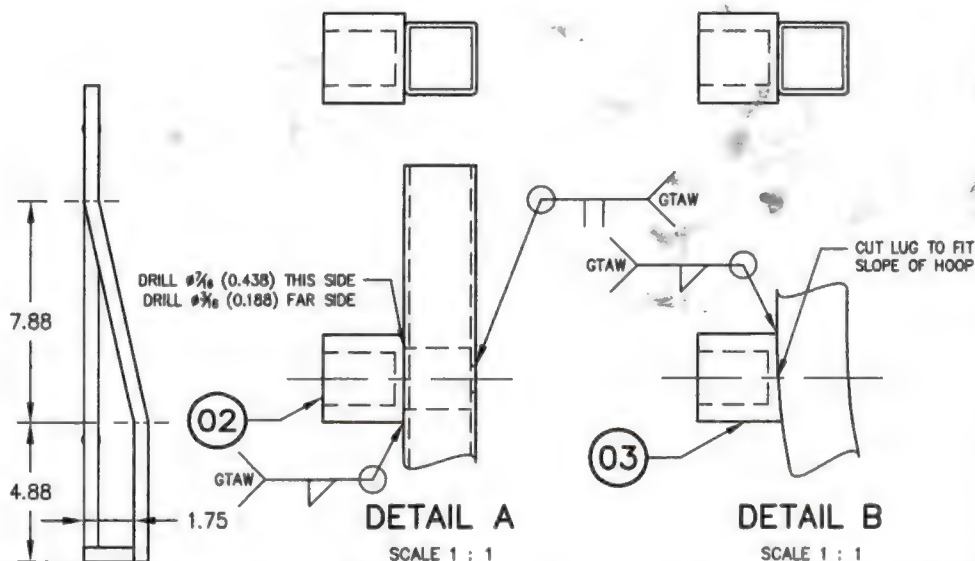


01 END HOOP
LH SHOWN, RH OPPOSITE

NOTES

1. REMOVE ALL BURRS AND BREAK SHARP EDGES.
2. DRILL #30 (0.129) VENT HOLE IN BOTTOM OF HOOP FOR VENTING OF WELD GASES.
3. WELDING OF LUGS TO BE COMPLETED BY GTAW METHOD TO AMS2685C. WELDING ROD SHALL CONFORM TO ER70S-2 OR EQUIVALENT.

REV.	DESCRIPTION OF CHANGE	INITIALS	DATE
0	CREATED FROM 94522, REV. 0		



QTY	QTY	PART NO.	ITEM	DESCRIPTION	MATERIAL	MATERIAL SPEC	STOCK SIZE
1	1	95925-03	03	LUG	1018 MILD STEEL	AISI 1010/1020	5/8 ROD
1	1	95925-02	02	LUG	1018 MILD STEEL	AISI 1010/1020	5/8 ROD
		95964-01-02	01	LH FWD ATTACHMENT HOOP	4130 STEEL COND. N	MIL-T-6736	1/2 x 0.035 SQR. TUBE
		95964-01-01	01	RH FWD ATTACHMENT HOOP	4130 STEEL COND. N	MIL-T-6736	1/2 x 0.035 SQR. TUBE

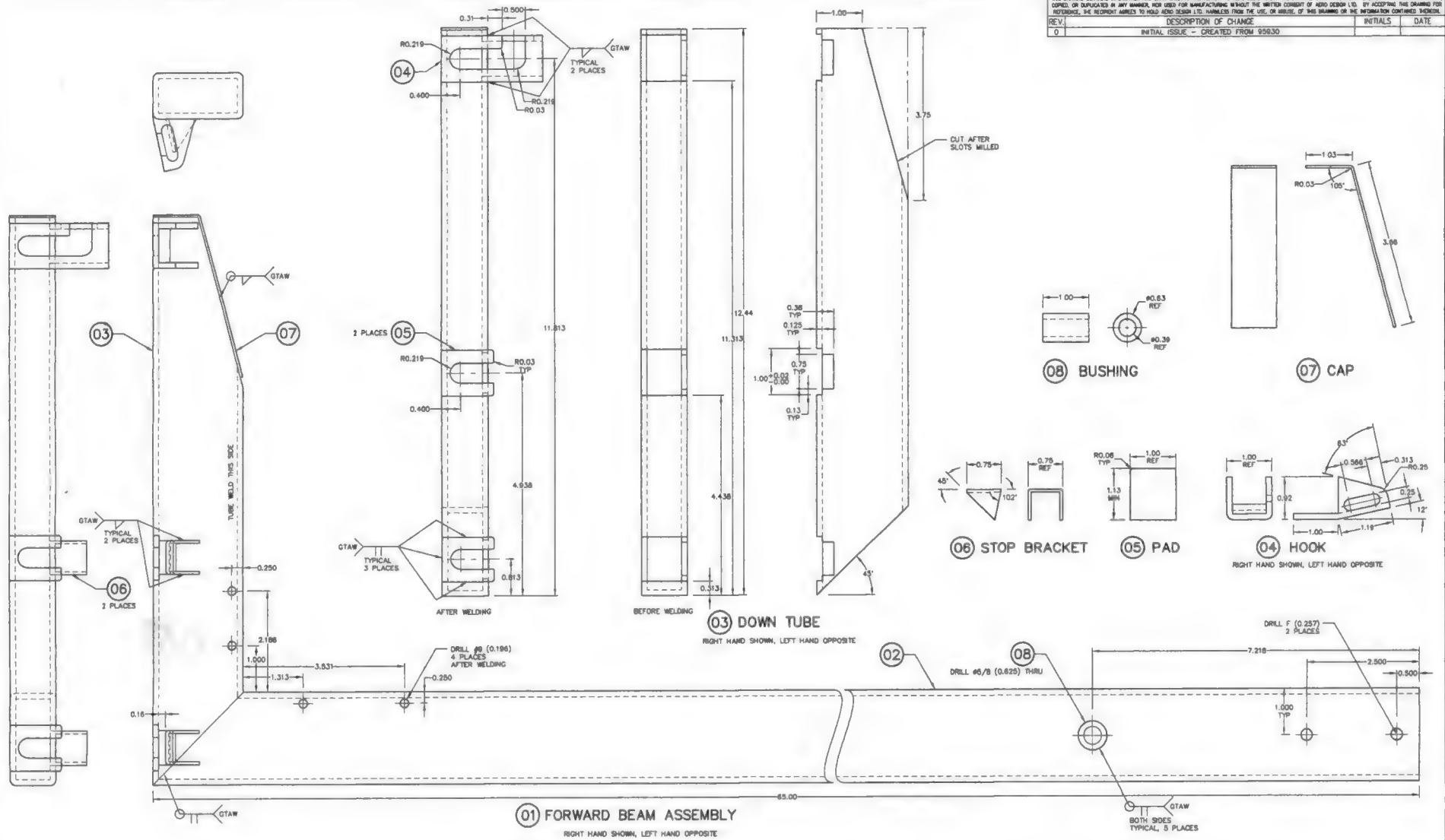
QTY	QTY	PART NO.	ITEM	DESCRIPTION	MATERIAL	MATERIAL SPEC	STOCK SIZE
1	1	95925-03	03	LUG	1018 MILD STEEL	AISI 1010/1020	5/8 ROD
1	1	95925-02	02	LUG	1018 MILD STEEL	AISI 1010/1020	5/8 ROD
		95964-01-02	01	LH FWD ATTACHMENT HOOP	4130 STEEL COND. N	MIL-T-6736	1/2 x 0.035 SQR. TUBE
		95964-01-01	01	RH FWD ATTACHMENT HOOP	4130 STEEL COND. N	MIL-T-6736	1/2 x 0.035 SQR. TUBE

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		SCALE 1 : 5	REV.
SHEET 1 OF 1	LGL	95964	0

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0	INITIAL ISSUE - CREATED FROM 95930		



NOTES

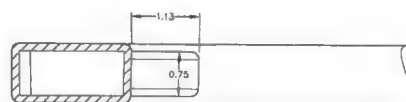
- REMOVE ALL BURRS AND BREAK SHARP EDGES.
- WELDING OF 304 STAINLESS STEEL TO BE COMPLETED BY GTAW METHOD TO AWS2885C. WELDING ROD SHALL CONFORM TO ER308L OR EQUIVALENT.
- THOROUGHLY DEGREASE AND POWDER COAT ALL STEEL PARTS AFTER WELDING. ALTERNATE: THOROUGHLY DEGREASE, EPOXY PRIME AND POLYURETHANE PAINT ALL STEEL PARTS AFTER WELDING.

QTY	QTY	QTY	PART NO.	ITEM	DESCRIPTION	MATERIAL	MATERIAL SPEC	STOCK SIZE
1	1		95930-08	08	BUSHING	316 STAINLESS STEEL	ASTM A286	0.875 X 0.120 RHOD TUBE
1	1		95930-07	07	CAP	304 STAINLESS STEEL	AMS 5513	0.625 X 1.125
2	2		95930-06	06	STOP BRACKET	304 STAINLESS STEEL	ASTM A554	0.75 X 0.035 SQR TUBE
1	1		95930-05	05	PAD	304 STAINLESS STEEL	ASTM A479	1 X 0.125 BAR
1	1		95930-04	04	LH HOOK	304 STAINLESS STEEL	ASTM A554	1 X 2 X 0.125 TUBE
1	1		95930-03	03	RH HOOK	304 STAINLESS STEEL	ASTM A554	1 X 2 X 0.125 TUBE
1	1		95930-02	02	DOWN TUBE	304 STAINLESS STEEL	ASTM A554	1 X 2 X 0.125 TUBE
1	1		95930-01	01	FORWARD BEAM ASSEMBLY	304 STAINLESS STEEL	ASTM A554	1 X 2 X 0.125 TUBE
1	1		95930-01	01	FORWARD BEAM ASSEMBLY	304 STAINLESS STEEL	ASTM A554	1 X 2 X 0.125 TUBE

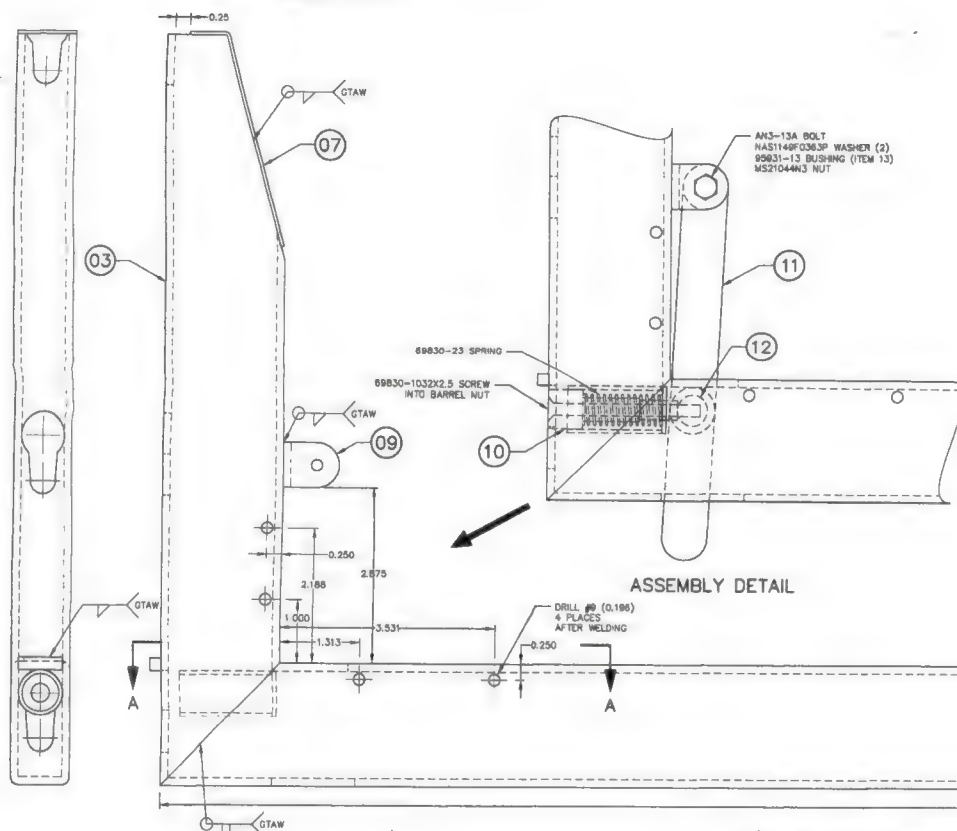
APPROVALS	DATE
DRAWN: JEFF CLARKE	30 JAN 2014
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DECIMALS	ANGLES
X.XXX ±0.010	±1/2°
X.XX ±0.03	
X.X ±0.1	

AERO DESIGN LTD. 8884 MALASPINA ROAD POWELL RIVER, BC, CANADA, V8B 0G3 TEL: 250 486 8296 www.aerodesign.ca		BELL 429 - S/N 57081 & SUB. QUICK RELEASE CARGO BASKET FORWARD BEAM FABRICATION	
		SCALE 1 : 1	REV
SHEET 1 OF 1	A1	95932	0

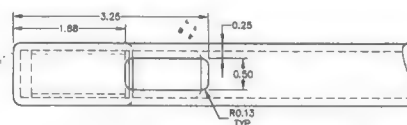
REV.	DESCRIPTION OF CHANGE	INITIALS	DATE
0	INITIAL ISSUE - CREATED FROM 05031 REV 0		



SECTION A-A




ASSEMBLY DETAIL



① AFT BEAM ASSEMBLY

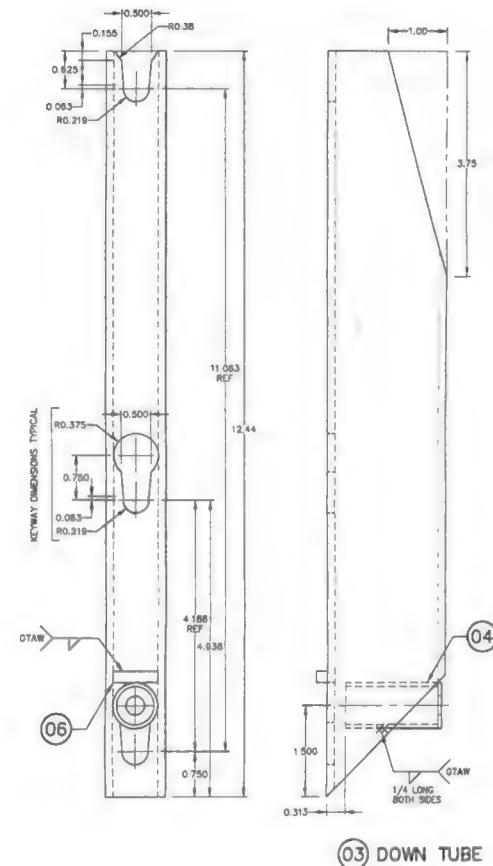
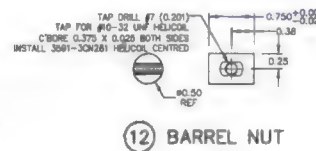
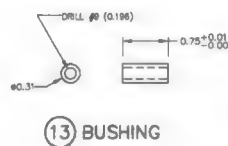
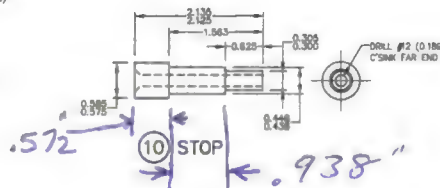
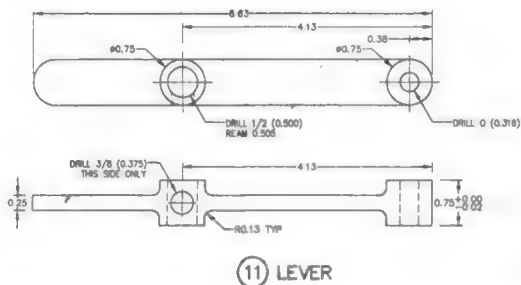
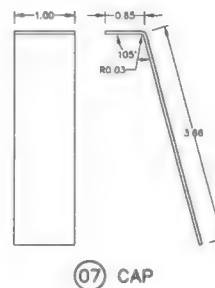
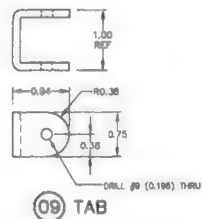
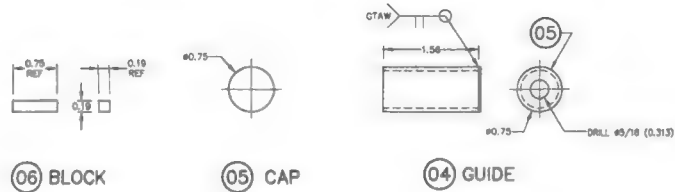
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CHECKED: JASON REKVE			
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DECIMALS	ANGLES		BELL 429 - S/N 57081 & SUB. QUICK RELEASE CARGO BASKET AFT BEAM FABRICATION
X.XXX ±0.010	DIMS. ±1/2"		
X.XX ±0.03			
X.X ±0.1			
SCALE 1 : 1		DWG. SIZE	REV.
SHEET 1 OF 2		A1	95933 0

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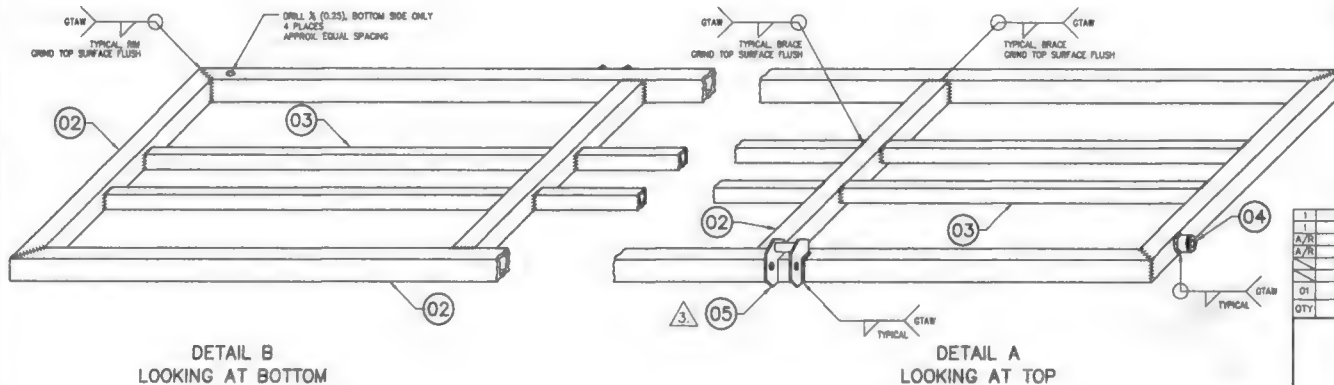
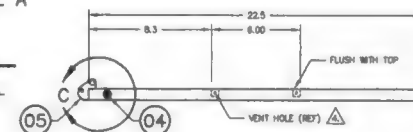
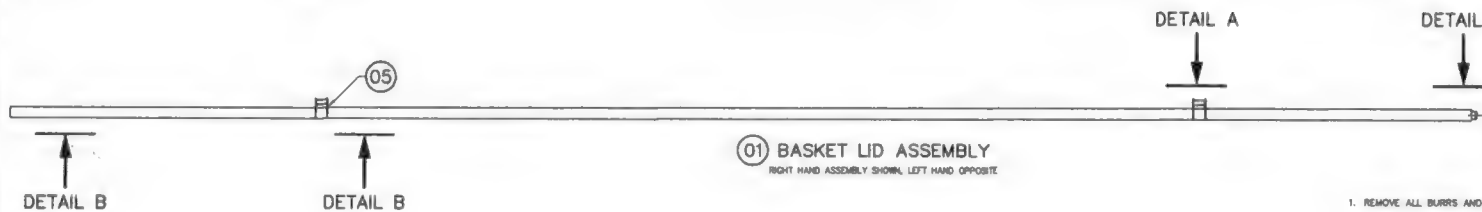
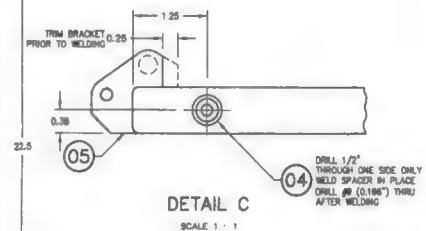
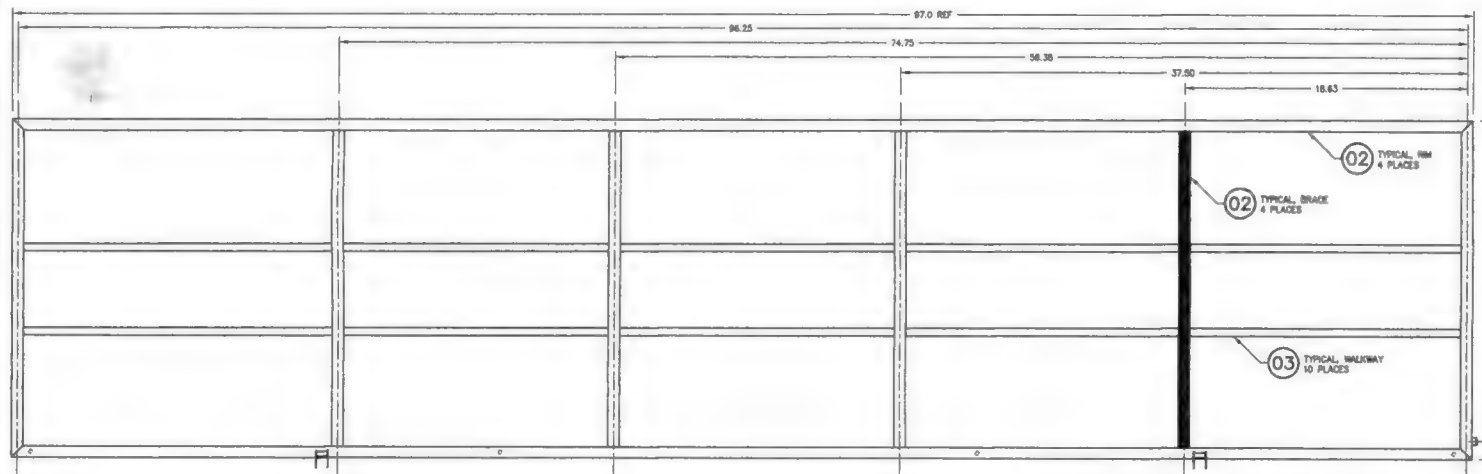
REV: DESCRIPTION OF CHANGE INITIALS DATE

0 INITIAL ISSUE - CREATED FROM 95937, REV. 0



APPROVALS	DATE	AERO DESIGN LTD.		
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UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES. TOLERANCES ON:		SCALE 1 : 1	SHEET NO.	REV.
DECIMALS ±0.010		A1	95933	0
FRACTIONS ±1/32"		SHEET 2 OF 2		
ANGLES ±0.1				

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REV	DESCRIPTION OF CHANGE	INITIALS	DATE
0	INITIAL RELEASE - CREATED FROM 94812		
1	TITLE BLOCK UPDATED; WELDING NOTES; HANDLE PROV P/N; BUMPER HOLES	BJC	20/03/2014



1. REMOVE ALL BURRS AND BREAK SHARP EDGES
2. WELDING OF 4130 STEEL TO BE COMPLETED BY GTAW METHOD TO AWS 2085C.
4130 AND 1018 STEEL: WELDING ROD SHALL CONFORM TO ER70S-2 OR EQUIVALENT.
STAINLESS AND 4130 STEEL: WELDING ROD SHALL CONFORM TO ER308L OR EQUIVALENT.
3. INSTALL ITEM 5 (LID HANDLE PROVISIONS ASSEMBLY) IN ACCORDANCE WITH AERO DESIGN LTD. DRAWING 84263 TYP 2 PLACES. NOTE BRACKET MODIFICATION SHOWN IN DETAIL C.
4. VENT 0.5" TUBES BY DRILLING #30 HOLE INTO 0.75" TUBES WHERE IT WILL BE COVERED BY THE 0.5" TUBE.
5. THOROUGHLY CLEAN AND POWDER COAT BASKET SUB-ASSEMBLIES PRIOR TO ASSEMBLY.

1	84263-01	05	LID HANDLE PROVISIONS ASSEMBLY			
1	49216-01	04	SPACER			
A/R	---	03	TUBE	4130 STEEL, COND. N	MIL-T-6736	0.5 X 0.035 SDR TUBE
A/R	---	02	TUBE	4130 STEEL, COND. N	MIL-T-6736	0.75 X 0.035 SDR TUBE
1	95912-01-02	01	LH BASKET LID ASSEMBLY			
1	95912-01-01	01	RH BASKET LID ASSEMBLY			
01	PART NO	ITEM	DESCRIPTION	MATERIAL	MATERIAL SPEC	STOCK SIZE
QTY	LIST OF MATERIALS					

APPROVALS		DATE		AERO DESIGN LTD.	
DRAWN:	JEFF CLARKE	11 SEPT 2012		8808A MALASPINA ROAD	
CHECKED:	E. BURGOIN	10 NOV 2012		POWELL RIVER, BC, CANADA, V8A 0G3	
				TEL: 604.485.5276 www.aerodesign.ca	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES.			BELL 429		
TOLERANCES ON:			QUICK RELEASE CARGO BASKET		
DECIMALS			BASKET LID ASSEMBLY		
ANGLES			SCALE 1 : 4		
X.XXX ±0.010 ±1/2"			DRG. SIZE DRG. NO. REV		
X.XX ±0.03			SHEET 1 OF 1		
X.X ±0.1			A1 95912 1		

MOUNTING BEAM FABRICATION – 95932/95933

General

These instructions apply to mounting beams 95932-01-XX (forward) and 95933-01-00 (aft) for Bell 429 (s/n 57081 & sub.) cargo baskets. Refer to the following drawings, at the current revision, for dimensions and details:

95932, Revision 0 – Forward Beam

95933, Revision 0 – Aft Beam

Work Order: 2014-84

Batch Quantity: 1 Fwd
1 Aft

Complete
(initial or SCA #)

Date Open: 24 OCT 2014

OK

1. Beam Fabrication – 1x2 tubes – 95932-01-XX / 95933-01-00

- Cut 1 x 2 x 0.12 material as indicated on drawings.
 - 95932-01-XX: 95932-02 (long tube), 95932-03-XX (down tube). ✓
 - 95933-01-00: 95933-02 (long tube), 95933-13 (down tube). ✓
 - One piece 4.44" long for 95932-04-XX (hook) and 95933-09 (tab). ✓
- Record material PO on attached material list.
- De-burr cut ends using a sanding disc on a die-grinder.
- Remove writing on tubes with acetone.
- Tag in-progress parts and place on in-progress shelf in machine shop for CNC machining of keyways, slots, and bushing holes.

2. CNC Machining – 95932-01-XX / 95933-01-01-00

- Run CNC programs to machine keyways, slots and holes in component parts.
- De-burr keyways, slots and holes.
- Tag in-progress parts and place on in-progress shelf in welding shop for welding.

OK

3. Beam Fabrication – Components – 95932-01-XX / 95933-01-00

Note: Some components are used for many different beams and are made in batches on separate component work orders. Check stock before making components.

- Cut pad 95932-05.
- Cut stop bracket 95932-06.
- Shear and bend cap 95932-07 and 95933-07. *2 pieces*
- Punch cap 95933-05. Flatten dimple with hammer.
- Cut and turn to length 95932-08 bushings, 95933-04 guide tube, 95933-10 stop, 95933-12 barrel nut, 95933-13 bushing :
 - Cut stock to length + 0.03-0.06".
 - Face one end flat @ 1000 RPM.
 - De-burr outside with a file and inside with de-burring tool at 300 RPM.
 - Setup stop and face other end to length @ 1000 RPM.
 - De-burr outside with a file and inside with a de-burring tool at 300 RPM.
- Thread and spotface 95933-12 barrel nut.
- Cut 95933-06 block.
- Cut 95932-04-XX hook and 95933-09 tab from stock after machining.

OK

- i. Cut stock for 95933-11 lever.
 - j. Record component POs / WOs on attached material list.
4. Beam Welding – 95932-03-XX Down Tube AD-05
- a. TIG weld 95932-04-XX hook and two 95932-05 pads onto 95932-03-XX down tube using ER308L rod.
 - b. Record component and welding rod POs / WOs on attached material list.
 - c. Tag in-progress parts and place on in-progress shelf in machine shop for CNC machining of keyways, slots, and bushing holes.
5. Beam Welding – 95933-04 Guide Tube AD-05
- a. TIG weld 95933-05 cap to end of 95933-04 guide tube using ER308L rod.
 - b. Tag in-progress parts and place on in-progress shelf in machine shop for turning.
6. CNC Machining – 95932-03-XX Down Tube JC
- a. Run CNC programs to machine keyways, slots and holes in component parts.
 - b. De-burr keyways, slots and holes.
 - c. Tag in-progress parts and place on in-progress shelf in welding shop for welding.
7. Turning – 95933-04 Guide Tube JC
- a. Turn outside diameter at weld flush with tube at 1000 RPM.
 - b. Drill through cap using 5/16" (#4) center drill at 300 RPM.
 - c. Deburr both sides of hole.
 - d. Tag in-progress parts and place on in-progress shelf in welding shop for welding.
8. Beam Welding – 95932-01-XX Forward Beam AD-05
- a. TIG weld 95932-08 bushing into 95932-02 tubes using ER308L rod, one place per tube, both sides. Ensure bushing is flush with sides of beam.
 - b. 45 degree corner: TIG weld 95932-02 tube (from a) to 95932-03-XX down tube (from a) using ER308L rod. Use corner vises to hold tubes square.
 - c. TIG weld components using ER308L rod:
 - i. 95932-06 stop brackets (2). Grind corner weld so lower bracket sits flat.
 - ii. 95932-07 cap.
 - d. Record component and welding rod POs / WOs on attached material list.
 - e. Tag in-progress parts for straightening.
9. Beam Welding – 95933-01-00 Aft Beam AD-05
- a. TIG weld 95932-08 bushing into 95933-02 tubes using ER308L rod, one place per tube, both sides. Ensure bushing is flush with sides of beam.
 - b. TIG weld 95933-04 guide tubes into 95933-03 down tubes using ER308L rod. Use jig to align guide tube to keyway. Refer to drawing for orientation and position.
 - c. 45 degree corners: TIG weld 95933-02 long tubes (from a) to 95933-03 down tubes (from b) using ER308L rod. Use corner vises to hold tubes square.
 - d. TIG weld components using ER308L rod:
 - i. 95933-09 tab to back of down tube.
 - ii. 95933-06 stop over bottom keyway.

- iii. 95933-07 cap. Ensure slot has sufficient clearance for basket fitting (96710-01).
- e. Record component and welding rod POs / WOs on attached material list.
- f. Tag in-progress parts for straightening.

10. Beam Straightening – 95932-01-XX / 95933-01-00



Note: straightening the beams is critical for ease of installation of the cargo basket.

- a. Straighten beams at strap using hydraulic press.
 - i. Set beam upside down on blocks as far apart as possible, locate ram over strap/bushing.
 - ii. Use a block to distribute press loads, about 2" wide
 - iii. Gradually work up to pressure required to make beam straight, usually more than 1000 psi is required. The same pressure generally works for beams from the same batch.
 - iv. Check for straight with a straight edge on bottom of tube. Ensure straight edge does not sit up on end cap.
- b. Straighten beams into plane using hydraulic press.
 - i. Check beams for plane by setting beam on a flat surface (welding table) on blocks. Use two blocks under long tube as far apart as possible. Attempt to slide block under end of down tube. Record direction and approximate distance to make block fit.
 - ii. Set beam on block under press ram, as close to corner at down tube as possible. Set the beam so that pushing down on the down tube will straighten the beam.
 - iii. Pressurize ram to 800 psi to hold beam.
 - iv. Clamp a snipe tube to down tube.
 - v. Push down on snipe tube. Note pressure on press for applied deflection. Similar deflections will require similar pressure.
 - vi. Check beams for plane, repeat steps ii-v if required.
- c. Break sharp edges off strap and stops using sanding disc on die-grinder.
- d. Tag in-progress parts and place on in-progress shelf in machine shop for CNC machining of holes.

11. CNC Machining – 95932-01-XX / 95933-01-00



- a. Machine holes in outboard end of beams for plate attachment.
- b. Tag in-progress parts for inspection.

12. CNC Machining – 95933-11 Lever



- a. Machine 95933-11 lever.
- b. Tag in-progress parts for inspection.

13. Final Inspection – 95932-01-XX / 95933-01-00



To be completed by a different person than the previous steps.

- a. Inspect beams 95932-01-XX and 95933-01-00 for conformity to drawing.
- b. Tag in-progress parts ready for powder coating.

14. Powder Coating



- a. Parts are to be powder coated in accordance with commercial practices.
- b. Record powder coating PO.
- c. Inspect powder coating on receiving.
- d. Tag in-progress parts ready for final assembly.



15. Final Assembly

To be completed after powder coating.

- a. Insert 95933-12 barrel nut and 95933-13 bushing into 95933-11 lever, and install lever into 95933-01 aft beam using AN3-13A bolt, NAS1149F0363P washer (2) and MS21044N3 nut through tab on inboard side of down tube.
- b. Install #10-32 x 3" countersunk screw, 95933-10 stop, and 69830-23 spring into guide in lower keyway. Check for function.
- c. Adhere P/N placard to top surface of beams, mid span.
- d. Green tag completed beam assemblies and place into stock.

Work Order: 2014-84Material Tracking Sheet
Bell 429 Aft Mounting Beams

1 of 2

Date Open: 24 OCT 2014Early S/N Late s/n

Ass'y Step	Qty	Detail Drawing	Part Number	Description	Material	PO/WO
			95933-01-00	Aft Beam Assembly		
Step 1				<i>Fabrication</i>		
	. 1		95933-02	Tube	304 Stainless, 1x2x0.125 tube	
	. 1		95931-03	Down Tube	304 Stainless, 1x2x0.125 tube	
	. 1		95931-09	Tab	304 Stainless, 1x2x0.125 tube	
Step 2				<i>Machining</i>	<i>None</i>	
Step 3				<i>Fabrication</i>		
	. 1		95931-04	Guide	316 Stainless, 5/8" x 0.120 tube	
	. 1		95931-05	Cap	304 Stainless, 0.050" Sheet	PO# 10037
	. 1		95931-06	Block	304 Stainless, 3/16" x 3/4" bar	
	. 1		95931-07	Cap	304 Stainless, 0.050" Sheet	PO# 10037
	. 1		95930-08	Bushing	316 Stainless, 5/8" x 0.120 tube	
	. 1		95931-10	Stop	6061-T6 Aluminum, 5/8" Rod	
	. 1		95931-11	Lever	6061-T6 Aluminum, 1.0 Sqr. Rod	
	. 1		95931-12	Barrel Nut	Brass - 1/2" Rod	
	. 1		95931-13	Bushing	Brass - 5/16" Rod	
Step 5				<i>Welding - guide tube</i>		
	. A/R		--	Welding Rod	ER308L	PO# 14005
Step 7				<i>Turning - guide tube</i>	<i>None</i>	
Step 9				<i>Welding</i>		
	. A/R		--	Welding Rod	ER308L	PO# 14005
Step 10				<i>Straightening</i>	<i>None</i>	
Step 11				<i>Machining</i>	<i>None</i>	

Work Order: 2014-84Material Tracking Sheet
Bell 429 Aft Mounting Beams

2 of 2

Date Open: _____

~~Early S/N~~ *late s/n*

Ass'y Step	Qty	Detail Drawing	Part Number	Description	Material	PO/WO
Step 12				<i>Machining - lever</i>	<i>None</i>	
Step 13				<i>Inspection</i>	<i>None</i>	
Step 14				<i>Powder Coating</i>		
Step 15				<i>Final Assembly</i>		
Step 15.a.	. 1		95931-11	Lever		above
	. 1		95931-12	Barrel Nut		above
	. 1		95931-13	Bushing		above
	. 1		AN3-13A	Bolt		
	. 2		NAS1149F0363P	Washer		
	. 1		MS21044N3	Nut		
Step 15.b.	. 1		95931-10	Stop		above
	. 1		69830-23	Spring	15mm x 70 mm Spring	
	. 1		69830-1032X3	#10-32 x 3 Screw	Stainless Steel, Commercial	
Step 15.c.	. 1		--	P/N Placard	TZ Tape, 1/2", black on white	

Work Order: 2014-84Date Opened: 24 OCT 2014

Material Tracking Sheet
 Bell 429 Forward Mounting Beams
~~Early S/N~~ *Late s/n*

1 of 2

Ass'y Step	Qty	Detail Drawing	Part Number	Description	Material	PO/WO
	<u>1</u>		95932-01- <u>01</u>	Forward Beam Assembly	(-01 RH, -02 LH)	
Step 1				<i>Fabrication</i>		
	. 1		95932-02	Tube	304 Stainless, 1x2x0.125 tube	<i>14020</i>
	. 1		95930-03-	Down Tube	304 Stainless, 1x2x0.125 tube	<i>14020</i>
	. 1		95930-04-	Hook	304 Stainless, 1x2x0.125 tube	<i>14020</i>
Step 2				<i>Machining</i>	<i>None</i>	
Step 3				<i>Fabrication</i>		
	. 2		95930-05	Pad	304 Stainless, 1 x 0.125 bar	<i>14020</i>
	. 2		95930-06	Stop Bracket	304 Stainless, 0.75x0.035" Sqr. Tube	<i>11101</i>
	. 1		95930-07	Cap	304 Stainless, 0.050" Sheet	<i>PO# 10037</i>
	. 1		95930-08	Bushing	316 Stainless, 5/8" x 0.120 tube	<i>90630-06 ALT PART # PO# 10119</i>
Step 4				<i>Welding - Down tube</i>		
	. A/R		--	Welding Rod	ER308L	<i>PO# 14005</i>
Step 6				<i>Machining - down tube</i>	<i>None</i>	
Step 8				<i>Welding</i>		
	. A/R		--	Welding Rod	ER308L	<i>PO# 14005</i>
Step 10				<i>Straightening</i>	<i>None</i>	
Step 11				<i>Machining</i>	<i>None</i>	
Step 13				<i>Inspection</i>	<i>None</i>	

Work Order: 2014-84

Date Opened: 24 Oct 2014

Material Tracking Sheet
Bell 429 Forward Mounting Beams
~~Early S/N~~ late s/n

2 of 2

Ass'y Step	Qty	Detail Drawing	Part Number	Description	Material	PO/WO
Step 14				Powder Coating		
Step 15				Final Assembly		
Step 15.c.	. 1		--	P/N Placard	TZ Tape, 1/2", black on white	



Aero Design Ltd.

AMF 73-04

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Canada

V8A 0G3

Complete Fabrication Instructions

This sheet is designed to assist in the fabrication of Aero Design products in accordance with the company Manufacturing Policy Manual, the Canadian Aviation Regulations and other applicable technical documentation.

The reference column of the following table is for reference unless a specific instruction is called out.

The initial columns serve one column per component fabricated on the applicable work order.

Nomenclature: Bell 407 Low Mounted Wide Aft Hoop Work Order #: 2014-84
Number of Units: _____

Bending Instructions

Model	Requirement	Reference	Initial				
Wide/Ski	Review LOEP to ensure most current technical specifications	DPM					
Wide/Ski	Cut 1/2" x 0.035 material to 54 5/16", square ends.	Drawing 94522	MR				
Wide/Ski	De-burr end cuts using appropriate methods	N/A	MR				
Wide/Ski	Remove writing on tubes using medium scotch bright and a light solvent.	N/A	MR				
Wide/Ski	On the manual tubing bender ADT-501, set the upper stop to 19 1/8".	Fig. 1	MR				
Wide/Ski	On the manual tubing bender ADT-501, set the lower stop to 105 degrees	Fig. 2	MR				
Wide/Ski	Slide stock tube through bending die ADT-501-003 up to upper stop.	Fig. 3	MR				



Figure 1



Figure 2



Figure 3

Caution:

Ensure the 1/2" tubing adapter remains tight against the tool rest throughout the bending process

Caution:

Ensure the tube remains tight against the stop until bend is started

Caution:

Ensure the draw bar handle remains horizontal throughout the bending process

Caution:

Be sure to pull draw bar in a medium speed constant pressure to ensure smooth radius

Note:

Complete each step on the first part and inspect for conformance to the applicable design data before continuing on to subsequent parts in the same batch

Wide/Ski	Pull draw bar ADT-501-002 until contact is made with the lower stop	Fig. 4/5	mm				
Wide/Ski	Remove material from the bending fixture.	N/A	mm				
	Measure and mark 33.25" from the long end of the tube.		mm				
Wide/Ski	With short end of tube pointing down, slide the long end of the tube into the 1" radius bender ADT-502 until the mark lines up with zero mark on the bender.	Fig. 6	mm				
Wide/Ski	Pull draw bar until the edge of the fixture reaches the 30 degree mark on the table.	Fig. 7	mm				
Wide/Ski	Remove material from the bending fixture.	N/A	mm				
Wide/Ski	Measure and mark 30.5" from the long end of the tube.	Fig. 8	mm				
Wide/Ski	With short end of tube pointing up, slide the long end of the tube into the 1" radius bender ADT-502 until the mark lines up with the zero mark on the bender.	Fig. 9	mm				
Wide/Ski	Pull draw bar until the edge of the fixture reaches the 30 degree mark on the table.	Fig. 7	mm				



Fig. 4



Fig. 5



Figure 6



Figure 7



Figure 8



Figure 9

Wide/Ski	On the manual tubing bender ADT-501 , set the upper stop to 19 9/32".	Fig. 1	<i>m</i>				
Wide/Ski	On the manual tubing bender ADT-501 , set the lower stop to 105 degrees.	Fig. 2	<i>m</i>				
Wide/Ski	Slide stock tube through bending die ADT-501-003 up to upper stop.	Fig. 3	<i>m</i>				

Caution:

Ensure the 1/2" tubing adapter remains tight against the tool rest throughout the bending process

Caution:

Ensure the tube remains tight against the stop until bend is started

Caution:

Ensure the draw bar handle remains horizontal throughout the bending process

Caution:

Be sure to pull draw bar in a medium speed constant pressure to ensure smooth radius

Wide/Ski	Pull draw bar until contact is made with the lower stop	Fig. 4/5	<i>m</i>				
Wide/Ski	Remove material from the bending fixture.	N/A	<i>m</i>				
Wide/Ski	On the leg opposite the 30 degree joggle, place marks at 4" and 11.5"	Fig. 10	<i>m</i>				
Wide/Ski	With hoop pointing up, slide the end of the tube into the 1" radius bender ADT-502 until the 9.5" mark is in line with the pivot point of the bender.	Fig. 11	<i>m</i>				
Wide/Ski	Pull draw bar until the edge of the fixture reaches the 15 degree mark on the table.	Fig. 12	<i>m</i>				
Wide/Ski	Remove material from the bending fixture.	N/A	<i>m</i>				
Wide/Ski	With the hoop pointing down, slide the end of the tube into the 1" radius bender ADT-502 until the 2.25" mark is in line with the pivot bolt on the bender.	Fig. 13	<i>m</i>				
Wide/Ski	Pull draw bar until the edge of the fixture reaches the 15 degree mark on the table.	Fig. 12	<i>m</i>				



Figure 10

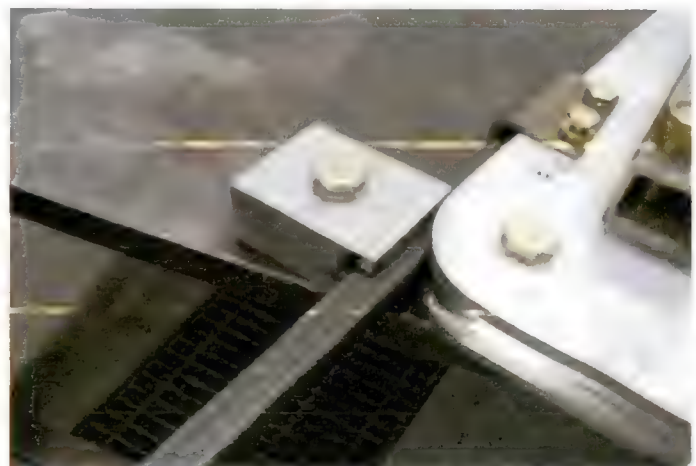


Figure 11



Figure 12



Figure 13

Milling Instructions

Wide/Ski	Install steel jaws in the manual milling machine vise.	Fig. 14	m					
Wide/Ski	Insert mounting leg of hoop in milling machine vise with the end of leg pointing to the right.	Fig. 15	m					



Figure 14

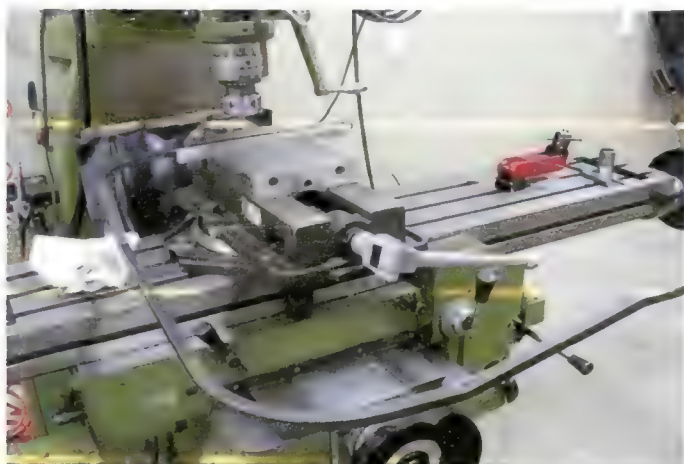


Figure 15

Caution:

Support the hoop using a backup bar in order to minimize deflection while milling. Fig. 15

Wide/Ski	Using 1/2" round bar, zero in X plane by touching off on the end of the tube by pinching feeler guage or paper to indicate contact.	Fig. 16	m					
Wide/Ski	Push ZERO button for X on the digital readout	Fig. 17	m					
Wide/Ski	Raise tool above the level of the material and shift left in X plane to -0.250	N/A	p					

Wide/Ski	Push ZERO button for X on the digital readout	Fig. 17	m					
Wide/Ski	Shift left to -2" on X plane and push ZERO button for X on digital readout	N/A	m					
Wide/Ski	Push ZERO button for X on the digital readout	Fig. 17	m					
Wide/Ski	Using 1/2" round bar, zero in Y plane by touching off on the backside of the tube by pinching feeler guage or paper to indicate contact.	N/A	m					
Wide/Ski	Push ZERO button for Y on the digital readout	Fig. 18	m					
Wide/Ski	Raise tool above the level of the material and shift forward in Y plane to -0.250	N/A	m					
Wide/Ski	Push ZERO button for Y on the digital readout	Fig. 18	m					



Figure 16



Figure 17



Figure 18

Caution:

Apply cutting oil to material surface at location to be milled

Wide/Ski	Using 5/8" (0.625) end mill, mill into side of tube.	Dwg. 94522	<i>m</i>				
All	Using appropriate methods, remove the excess cutting fluid from the surface and inside of the tube.	N/A	<i>m</i>				
All	De-burr milled cuts using appropriate methods.	N/A	<i>m</i>				
Wide/Ski	Using a #30 bit, drill vent holes for spine as indicated in note #2 on drawing.	Dwg. 94620	<i>m</i>				
All	De-burr holes using appropriate methods	N/A	<i>m</i>				

Welding Instructions

All	Attach two 69823-02 lugs to ADT-104-002 spacing jig using 3/8-24 bolt.	Fig. 19	<i>m</i>				
All	Install the lugs mounted in the mounting jig assembly into slots milled in the hoop.	Dwg. 94522	<i>m</i>				










Figure 19

Caution:

Ensure the lugs are centered laterally in tube before welding.

All	TIG weld both mounting lugs to hoop assembly around the entire mating surface between the two parts.	AWSD17.1/ D17.1M:2010	<i>DM</i>				
-----	--	--------------------------	-----------	--	--	--	--

Final Completion

All	Remove the ADT-104-002 jig fixture from the hoop assembly.	N/A					
All	De-burr threaded holes in lug using a 3/8-24 tap.	Standard Practice					
All	Inspect completed parts for quality of finish.	Standard Practice					
All	Using a flash light and a 10 power magnifying glass, inspect all weldments for quality and discoloration.	AWSD17.1/ D17.1M:2010					
All	Record the purchase order number and serial number (if required) on the Parts Distribution Sheet.	DIR					
All	Tag completed parts using an In-Process tag with the details of the work performed.	DIR					
All	Place completed assemblies in stores for distribution.	N/A					

Post Fabrication Inspection

Inspect components to ensure conformity to the applicable design data.

Signature:  _____

Licence Number or SCA: AD01 _____

Date: 24 Oct 14 _____

Date Opened: 24 October 2014

Job #: 959-1

Type / Project: Bell 429 (Post - S/N 57081) Cargo Basket and Mounts

Batch Quantity: 1

Approval: SH12-58

Drawing List: DCL959-15, Rev. 0, DCL959-16, DCL969-11

Drawing	Description	Task Sheet		Material List	
		Provided	Complete	Provided	Complete
95950, Rev. 0	Cargo Basket Assembly	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>
- 84255, Rev. 1	Handle Assembly				
- 84240, Rev. 0	Lid Prop Installation				
95951, Rev. 0	Basket Body Fabrication	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>
95912, Rev. 1	Basket Lid Fabrication	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>
- 84263, Rev. 0	Lid Handle Provisions				
95964, Rev. 0	Forward Attachment Hoop	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>
95916, Rev. 1	Filler Sheet	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>
95917, Rev. 1	Lid Sheet	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>
95965, Rev. 0	Forward Sheet	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>
95926, Rev. 1	Aft Attachment Hoop	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>
94520, Rev. 0	Hoop	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>
- 84262, Rev. 1	Basket Handle Provisions				
84261, Rev. 1	Handle Bar Assembly	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>
95932, Rev. 0	Forward Beam	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>
95933, Rev. 0	Aft Beam	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>
95940, Rev. 0	Lugs	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>
95942, Rev. 0	Plates	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>
95923, Rev. 1	Bushings	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>

96910, Rev. 1	Fixed Cabin Step Assembly	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>
- 96921 Rev. 1	End Bracket				
96911, Rev. 1	Quick Release Cabin Step Assembly	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>
- 96922 Rev. 1	End Bracket				

Work Order pre-completion Inspection:

Project is on Approval Limitation Record:	<u>Y</u>
Document Control List revision level matches (or exceeds) STC:	<u>Y</u>
Drawings revision levels match Document Control List:	<u>Y</u>
Purchase order or Work order source is recorded for each part/ass'y:	<u>Y</u>
Tests and inspections specifically called out on drawings are complete:	<u>Y</u>
Release tags associated with all fabricated parts are attached:	<u>Y</u>

List all non-conformities raised: _____



Inspector Signature:

Date: _____



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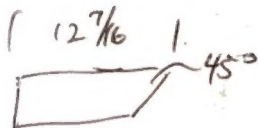
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1 @ 4 $\frac{7}{16}$

PO 13088

WO 2014-84



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